

Work Order ID 99754

June-21-13 2:43:49 PM

Rush

Report

99754

Page 1

Item ID: D3296-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Door Panel
 Start Date: 4/12/13 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 4/12/13 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3296	B								

100 0.00
 100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D3296
 2024.063 Dwg Rev: *B*
 Prog Rev: *B*
 2-Deburr if necessary
 8 0 Jm13-06-22

110 0.00
 110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control
 8 0 Jm13-06-22

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Item ID: D3296-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Panel

Start Date: 4/12/13

Start Qty: 6.00

6

Cust Item ID:

Required Date: 4/12/13

Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									

(8) 13-06-24

DA
09
08

8 7613625

8K

EP 13/06/15

99754

June-21-13 2:43:49 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 4/12/13 **Start Qty:** 6.00

6

Customer:

Required Date: 4/12/13 **Req'd Qty:** 6.00

6

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

160

Identify as per dwg & Stock Location:

C-A

Set Up/Run Hours

0.00

160

Packaging

Memo

0,00

Packaging

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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8x

Number Stamp

13/6/26 *[Signature]*

pl B-06-25

Picklist Print

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Page 1

Work Order ID: 99754

Parent Item: D3296-1

Parent Item Name: Door Panel

Start Date: 4/12/13

Required Date: 4/12/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14Added step 14KJ/EC
IPP Rev:D Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063 2024-T3 .063 sheet		Purchased	No			100	sf	567.5489	0.6596	4.1658948	5.0		Jm 30622

Location

Loc Qty

Loc Code

MAT022

567.5489

119916

0.2

121197

21.34

123096

11.4

123654

11.64

123701

49.5289

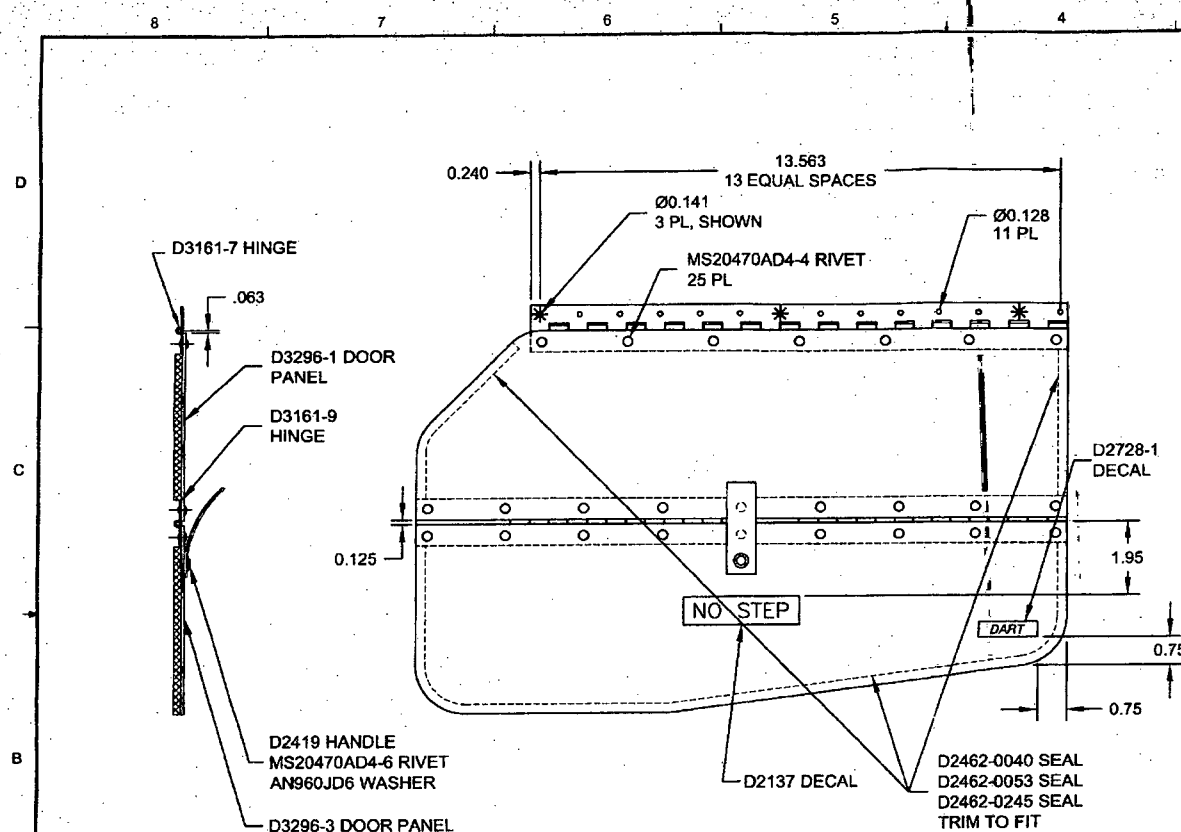
125341

89.44

125636

384

125636



D3296-041 DOOR ASSEMBLY

D3296-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

QTY -041	PART NUMBER	DESCRIPTION
X	D3296-041	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

RELEASED
2012-11-21

B	ADD D3296-041B. REF. PAR12-223.	MB	12.11.15
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.11.15		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3296
TITLE DOOR ASSEMBLY
REV. B
SHEET 1 OF 3
SCALE
NTS

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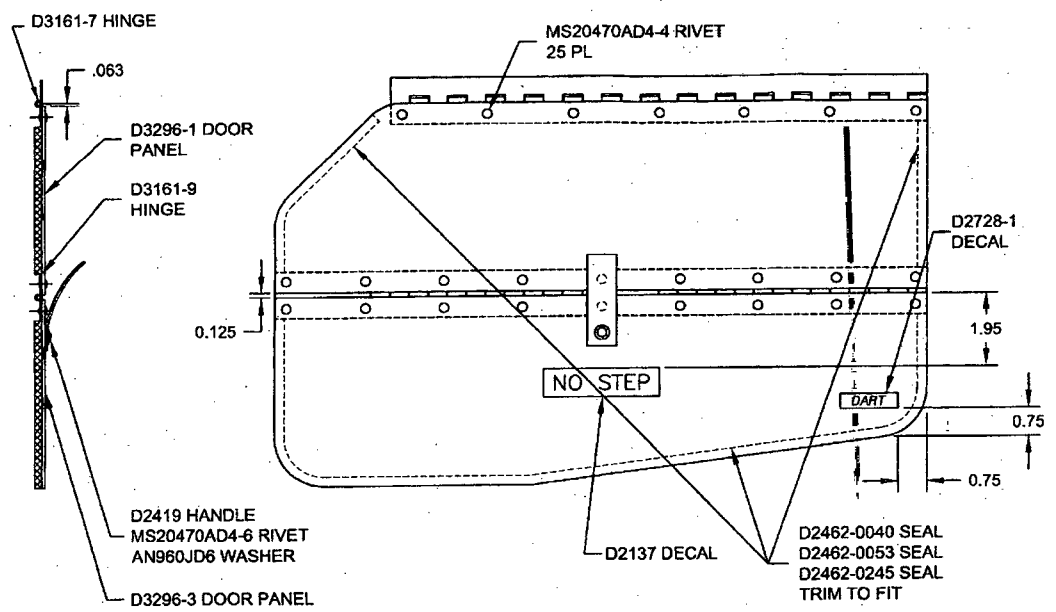
8 7 6 5 4 3 2 1

D

C

B

A



D3296-041B DOOR ASSEMBLY, BLANK

QTY -041B	PART NUMBER	DESCRIPTION
X	D3296-041B	DOOR ASSEMBLY
1	D2419	HANDLE
2	D2462-0040	SEAL
1	D2462-0053	SEAL
1	D2462-0245	SEAL
1	D2728-1	DECAL
1	D2137	DECAL
1	D3161-7	HINGE
1	D3161-9	HINGE
1	D3296-1	DOOR PANEL
1	D3296-3	DOOR PANEL
1	NAS1149DN632J	WASHER (OR AN960JD6)
25	MS20470AD4-4	RIVET
1	MS20470AD4-6	RIVET

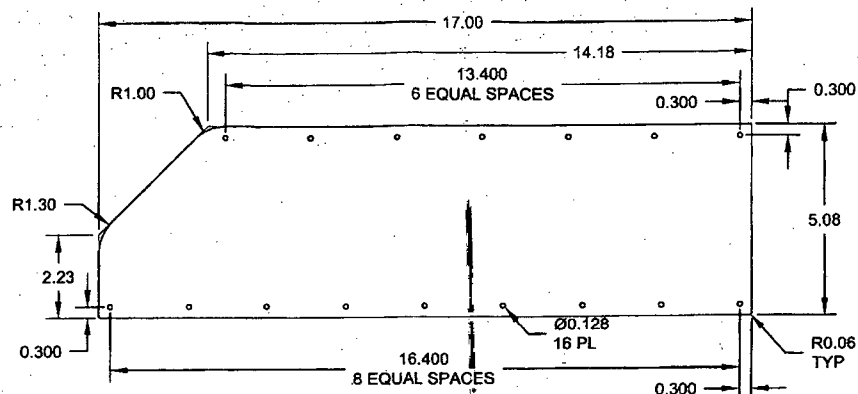
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2012-11-21
MPO

D3296-041B NOTES:

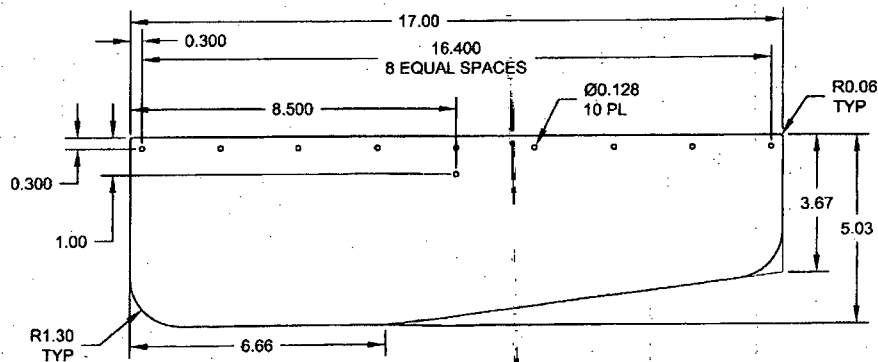
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.8 lbs
- 8) INSTALL D2137 AND D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COATING
- 9) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE

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DATE	12.11.15		

8 7 6 5 4 3 2 1



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1/-3 NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209 REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3296-1 = 0.52 lbs; D3296-3 = 0.50 lbs

DESIGN	99	DART AEROSPACE LTD	
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